Work Order ID 66017

Tuesday, February 01, 2011 3:51:20 PM

Item ID: D412-750-142 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Tail Light Fairing, RH

Start Date: 2/1/2011 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 2/7/2011 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 11-02-11 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
N/A	Rev A								
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy bluefile & type labels per PPP D412-750-142 CHG001								
110	Pick Kit	0.00							
Packaging	**Memo**	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
QC	**Memo**	0.00							
Quality Control	***** Ensure part is a R/H as per dwg *****								

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 66017

Tuesday, February 01, 2011 3:51:20 PM

Item ID: D412-750-142 **Accept** **Setup Start**

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Start Date: 2/1/2011 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 2/7/2011 **Req'd Qty:** 4.00 **Customer:**

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				1 1 2 3			40
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP D412-750-142 □Location: 22 □PPP Rev: A								
140	QC21- Final Inspection - Work Order Release	0.00					11 02 04		
QC	**Memo**	0.00							
Quality Control									

CMF

11-02-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, February 01, 2011 3:51:25 PM

Work Order ID: 66017

Parent Item: D412-750-142

Parent Item Name: Tail Light Fairing, RH

Start Date: 2/1/2011 **Required Date:** 2/7/2011

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP revA 06.09.22 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-3A		Purchased	No			120	Each	191.0000	10	40			
Bolt													
				Location			**Loc Qty**		**Loc Code**				
				ST350			191						
					116419		141						
					116590		50			40			
AN960JD10	NAS1149D0363J	Purchased	No			120	Each	8.0000	10	40			
Washer													
				Location			**Loc Qty**		**Loc Code**				
				ST			6						
					107715		6						
				ST335			2						
					105792		2						
D3484-042		Manufactured	No			120	Each	4.0000	1	4			
Tail Light Fairing Assembly, RH													
				Location			**Loc Qty**		**Loc Code**				
				ST205			4						
					52998		4			4			

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

3.8 Fasten the D3484-041/-042 Tail Light Fairing complete with A2064-1683 Tail Light Assemlby to the tailboom using the provided (10) AN3-3A bolts into the tailboom's existing holes. Torque bolts 15-25 lb·in (1.7-2.8 N·m). Refer to Figure 1, Detail A.

4.0 WEIGHT AND BALANCE

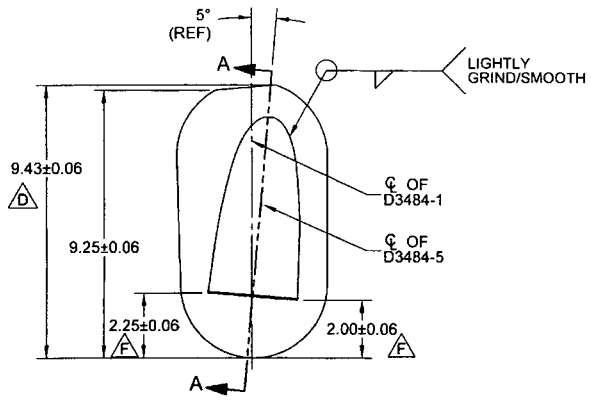
The following is the net weight increase associated with the installation of the D412-750-141/-142 Tail Light Fairing Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-750-141 *Tail Light Fairing Kit, LH*	0.13 lb 0.06 kg	6.0 in 0.2 m	0.78 lb-in 0.01 kg-m	296.1 in 7.5 m	38.49 lb-in 0.45 kg-m
D412-750-142 *Tail Light Fairing Kit, RH*	0.13 lb 0.06 kg	6.0 in 0.2 m	0.78 lb-in 0.01 kg-m	296.1 in 7.5 m	38.49 lb-in 0.45 kg-m

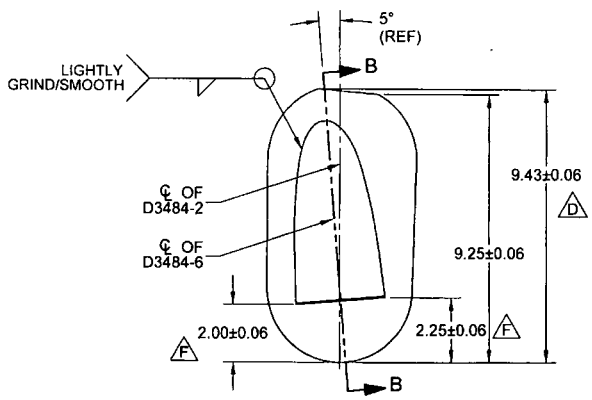
5.0 PARTS LIST

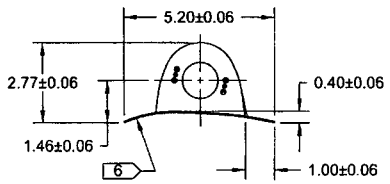
Qty – 141	Qty – 142	Part Number	Description
X		**D412-750-141**	**TAIL LIGHT FAIRING KIT, LH**
	X	**D412-750-142**	**TAIL LIGHT FAIRING KIT, RH**
1		D3484-041	TAIL LIGHT FAIRING ASS'Y, LH
	1	D3484-042	TAIL LIGHT FAIRING ASS'Y, RH
10	10	AN3-3A	BOLT
10	10	AN960JD10	WASHER

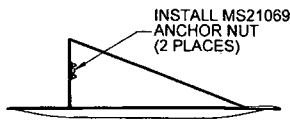
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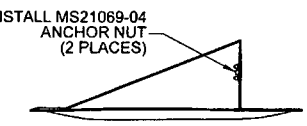
QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT



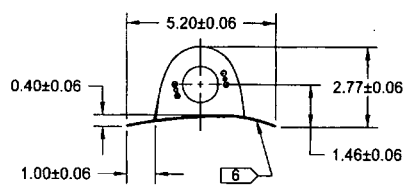




SECTION A-A



SECTION B-B

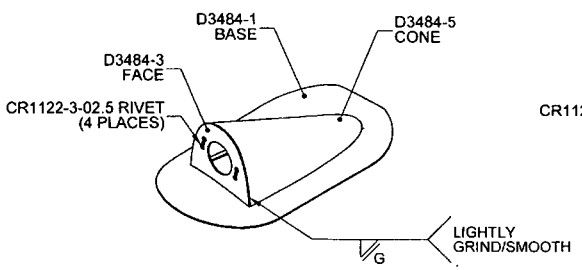


D3484-041 TAIL LIGHT FAIRING

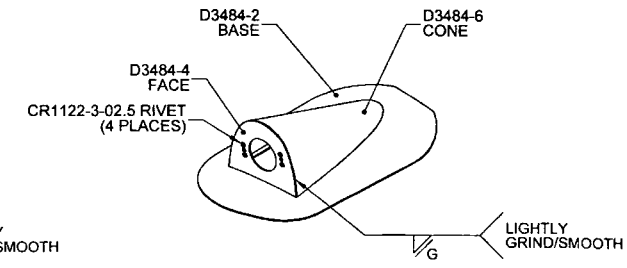
D3484-042 TAIL LIGHT FAIRING

RELEASED 09/09/24 MW

REFERENCE ONLY



D3484-041 ISOMETRIC VIEW



D3484-042 ISOMETRIC VIEW

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) WELDING: PER DART QSI 004
6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
7) WEIGHT: 0.30 lbs

REV.	DESCRIPTION	BY	DATE
F	UPDATE MATERIAL SPEC, ADD 6061-0, ZN A7-2, A7-3, B3-4. UPDATE DIMENSIONS ZN C1-1, C2-1, C7-1, C8-1 UPDATE WELDING NOTE ZN A3-1, A6-1		09.03.31
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY; CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/-5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. F
MFG. APPR.		D3484 SHEET 1 OF 4
APPROVED		TITLE SCALE
DE APPR.		TAIL LIGHT FAIRING 1:4
DATE	09.03.31	

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